




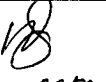
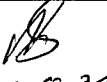
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23381
<b>Description:</b> Step Weldment Assembly		<b>Part Number:</b>	D3438-042
<b>Dwg:</b> D3438 Rev. A		<b>Qty:</b>	4
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	ph	05.05.19	4																				
2	WA	Cut D2244 to 79.63" at 34° as per Dwg D3438 Batch: 321597	le	05.05.19	4																				
3	WA	Deburr ends	le	05.05.19	4																				
4	WA	Inspect for foreign objects as per QSI 024	le	05.05.19	4																				
5	WA	Weld using DT8343 as per Dwg D3438 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2561</td><td>Lug Plate</td><td>323223</td></tr><tr><td>2</td><td>D2564</td><td>Mounting Angle</td><td>323225</td></tr><tr><td>2</td><td>D2673-34</td><td>End Cap</td><td>323259</td></tr><tr><td>A/R</td><td>N/A</td><td>Aluminium Rod</td><td>1016377</td></tr></table>	Qty	Part Number	Description	Batch	2	D2561	Lug Plate	323223	2	D2564	Mounting Angle	323225	2	D2673-34	End Cap	323259	A/R	N/A	Aluminium Rod	1016377	le	05.05.20	4
Qty	Part Number	Description	Batch																						
2	D2561	Lug Plate	323223																						
2	D2564	Mounting Angle	323225																						
2	D2673-34	End Cap	323259																						
A/R	N/A	Aluminium Rod	1016377																						
6	WA	Grind	le	05.05.20	4																				
7	QC9/5	Inspect welding and work to Step 6	2	05.05.24	4																				
8	FP	Acid etch and Alodine as per QSI 005 4.1	ml	05.05.25	4																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ml	05.05.25	4																				
10	FP	Wing Walk as per Dwg 3438 and QSI 005 4.4 <b>Mask off 0.5 each side of D2561 lugs</b>	ml	05.05.26	4																				
11	QC3	Inspect Powder Coat and Wing Walk																							
12	ST	Identify and Stock																							
13	AC	Cost / part: 608.97	Sgt	05-08-02																					
14	DC	Close W/O Inspect Level 21																							

Rev	Date	Change	Revised By	Approved
A	05.05.18	New Issue	KJ/JLM	

**RELEASED**  
05.05.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-20	5	when welding final weld to seal step the weld even if close. Numerous attempts to seal the step failed	 10/05/20	replace & give step to eng.	 05-05-20	 15-05-20	 10-05-20	 05-05-20
		See NCR 885						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

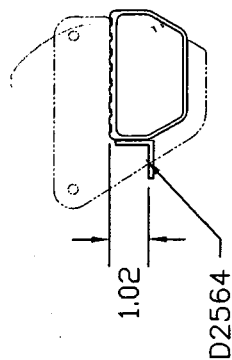
NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

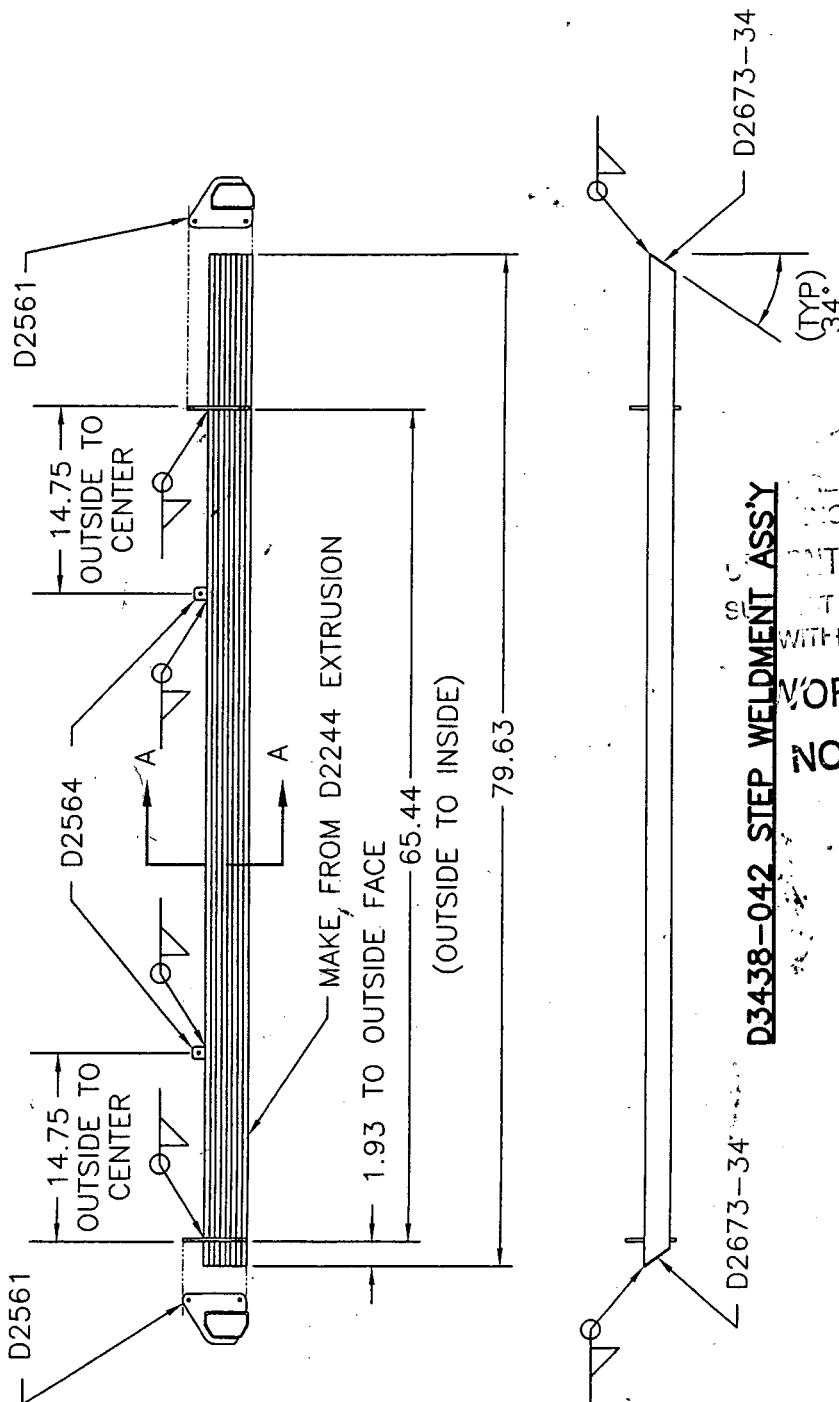
# DART

## PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09		TITLE STEP WELDMENT ASSEMBLY	SCALE 1:1
A	05.05.09	NEW ISSUE	



SECTION A-A



**D3438-042 STEP WELDMENT ASS'Y**

TOP COPY  
RETURN TO  
ENGINEERING  
DATE LED COPY  
NOT TO AMENDMENT  
WITHOUT NOTICE  
**WORK ORDER**  
**NO. 23381**

### NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1  
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 18, 2005  
03:08 pm

Work Order No : 0023381  
Project Name : D3438-042  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3438-042  
Description :  
Manufactured : No  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 05-18-05  
Est Finish Date : 05-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00